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C2-18B

Job Sheet 183519



Part No: C2-18B

Job Qty: 1 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C2-18B Rev. 2 IPP Rev. A 18.09.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/19/18	0.00	0.00	Start Up Large Fab-7		<i>EL</i>
100	Large Fab	1 pcs		10/19/18	0.00	10.00	Large Fab 8		<i>EL</i>
110	QC	1 pcs		10/19/18	0.00	0.00	QC9		<i>EL</i>
120	QC	1 pcs		10/19/18	0.00	0.00	QC5		<i>EL</i>
130	Powdercoat	1 pcs		10/19/18	0.00	0.50	Powdercoat6		<i>EL</i>
140	QC	1 pcs		10/19/18	0.00	0.00	QC3		<i>EL</i>
150	Packaging	1 pcs		10/19/18	0.00	0.00	Packaging3-2		<i>EL</i>
160	QC21-SA	1 Ea		10/19/18	0.00	0.00	QC21		<i>EL</i>

Part Op 100 - 1-MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: _____ 2-Weld as per DWG. ***ALL Descriptions: HOLES MUST ALIGN***

130 - START TIME: 3:05 OVEN TEMPERATURE: 320° FINISH TIME: 3:35

M 129203

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C2-20-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	<i>568682</i>
MT-A513-T-0.8750W0.120	A513 Seamless Alloy Steel Round Tubing 0.875"dia. x 7.5000 ft (7.5 ea) 0.120" Wall		90-Start up Operation	<i>5116715</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C2-20-1	2	10	0
	MT-A513-T-0.8750W0.120	8	82	0



Container No: S118159



Part: C2-18B
Job No: 183519
Serial No/Batch: S118159
Revision: 2
Inspector:
Exp Date:
Instructions:

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found.

Plex 9/19/18 10:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

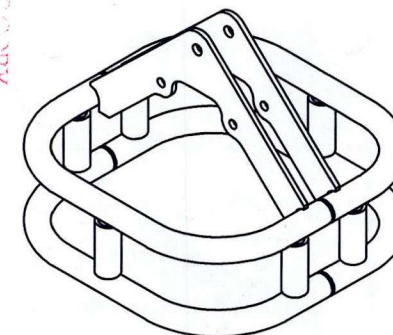
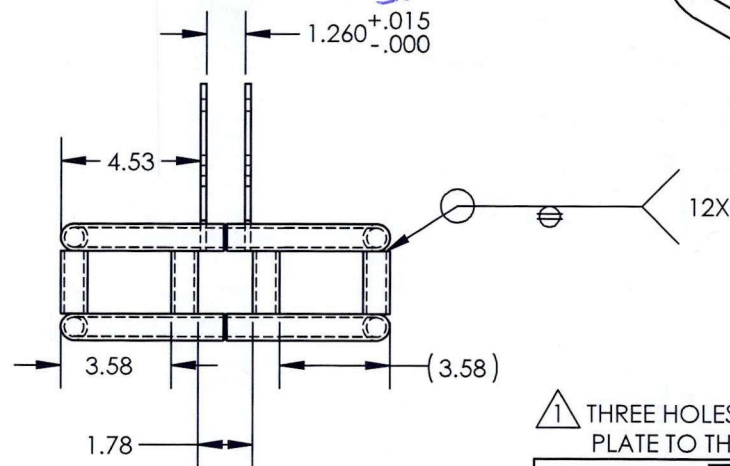
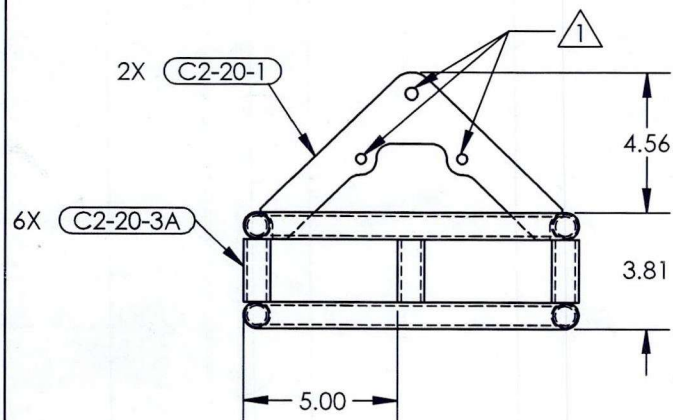
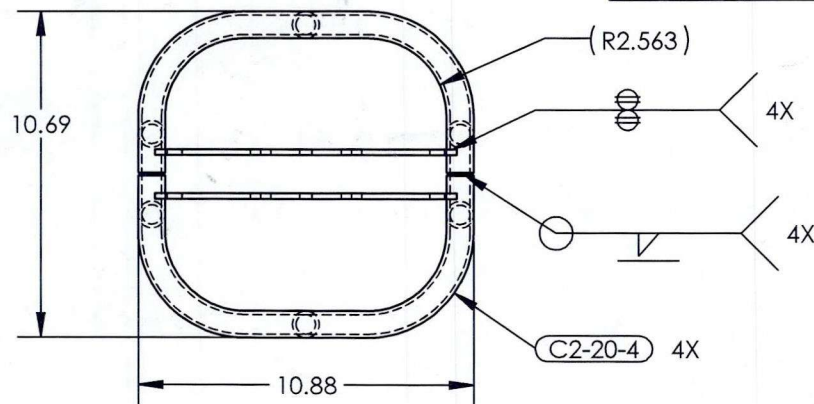
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0098	UPDATED TO NEW STANDARD. CH'D DIMS WAS 10.688 IS 10.69, WAS 10.875 IS 10.88, WAS 1.780 IS 1.78, WAS (R2.813) IS (R2.563). CH'D TOLERANCES WAS .XXX $\pm$.005 IS .XXX $\pm$.010, WAS .XX $\pm$.01 IS .XX $\pm$.03. REMOVED FINISH SPEC.			8/9/2016	DEW	SM



△ THREE HOLES MUST BE ALIGNED FROM FRONT PLATE TO THE BACK PLATE.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
			C2-20-4	4	UPPER RING
			C2-20-1	2	LIFTING PLATE
			C2-20-3A	6	SIDE BAR

C2-18B
WELDMENT

DART AEROSPACE	
TITLE: WELDMENT C2 RING CAGE	
DWG NO. C2-18B	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT RED	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$.03 ANGLES $\pm$ 1°
	.X $\pm$.1 SURFACES = 125/
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	
SCALE 1:6	DATE
SHEET 1 OF 1	